

Work Order ID 129469-2

Wednesday, February 11, 2015 2:21:03 PM

129469

Page 1

Item ID: D3774-1

Revision ID:

Item Name: Seat Bottom, LH/RH

Start Date: 2/11/2015 Start Qty: 4.00

Required Date: 2/11/2015 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MJS

QC:

Date: 15-02-11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start *NS1*

Stop *NS2*

N900040100

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3774	Rev B								
100	HAND FINISHING THERMOFORMING	0.00							
100									
Thermoform	Memo	0.00							
Thermoforming Machine	Set up machine program D3774-1 Set up clamping frame as per folio								
110	HAND FINISHING THERMOFORMING	0.00							
110									
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

15/02/17

15/02/18

4

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Wednesday, February 11, 2015 2:21:03 PM

Item ID: D3774-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Seat Bottom, LH/RH

Start Date: 2/11/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/11/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

115

115

HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 245° F

Time IN: 4:30 PM

Time OUT: 7:00 AM

0.00

0.00

B 15/02/18

120

120

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

Thermoform as per Dwg. D3774-1 and Folio

Dwg. Rev. B

Folio Rev. C

Visually inspect for proper formation of each part

0.00

0.00

4pc

B 15/02/18

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Item ID: D3774-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Seat Bottom, LH/RH

Start Date: 2/11/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/11/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

140

140

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Trim to Finished Dimensions

0.00

0.00

3

B 15/02/19

150

150

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

1) Check dimensions to ensure conformity to drawing tolerances.

0.00

0.00

B 15/02/19

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

3

DAS
38
9-89
FEB 20 2015

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Page 4

Wednesday, February 11, 2015 2:21:03 PM

Item ID: D3774-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Seat Bottom, LH/RH

Start Date: 2/11/2015 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 2/11/2015 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location St 240

0.00

170

Packaging

Memo

0.00

Packaging

FEB 21 2015

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

DAS
06
5-10

15/2/23

15-2-23

Picklist Print

Wednesday, February 11, 2015 2:21:08 PM

Page 1

Work Order ID: 129469

129469

Parent Item: D3774-1

D3774-1

Parent Item Name: Seat Bottom, LH/RH

Start Date: 2/11/2015

Required Date: 2/11/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: A New Issue 08.06.04 DL verified by: DD
IPP REV: B Dwg. Update 08.08.19 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

110

sf

1,837.867

10.667

51

MI FXS 125-F60029-04

**

GE PLASTICS LEXAN SHEET

BP 15/02/18

Location

Loc Qty

Loc Code

MAT019

1837.8676

m129759

110.3334

m130209

1727.5342

DART AEROSPACE LTD	Work Order:	129469
Description: Seat-Back <u>Bottom</u>	Part Number:	D3774-1
Inspection Dwg: D3774-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 15/02/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.31	✓	✓		DL-02
33.9	+/-0.100	33.875	✓	✓		DL-02 TH-05
0.085	Min	.105	✓	✓		DL-02
0.100	Min	.111	✓	✓		TH-D1
0.100	Min	.116	✓	✓		TH-D1
0.100	Min	.115	✓	✓		TH-D1
0.100	Min	.115	✓	✓		TH-D1
0.100	Min					
0.100	Min					
0.100	Min					
0.100	Min					

Measured by: BB BB DAS

Date: 15/02/18 18/02/19

Audited by: 9-89

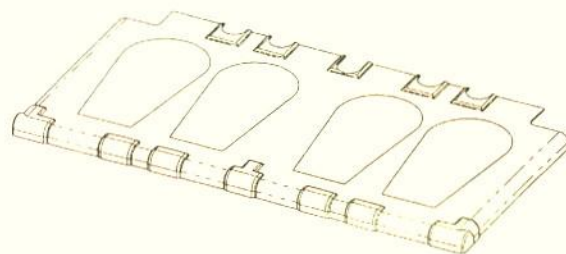
Date: FFP 24 2015

Prototype Approval:

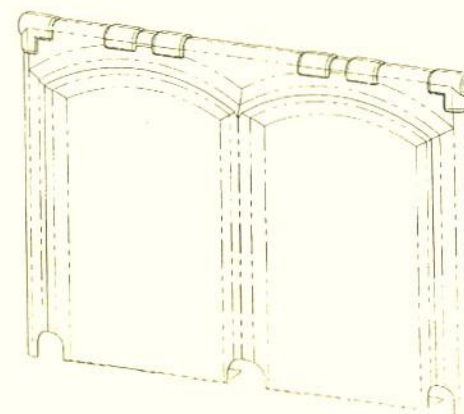
N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	



D3774-1 SEAT BOTTOM

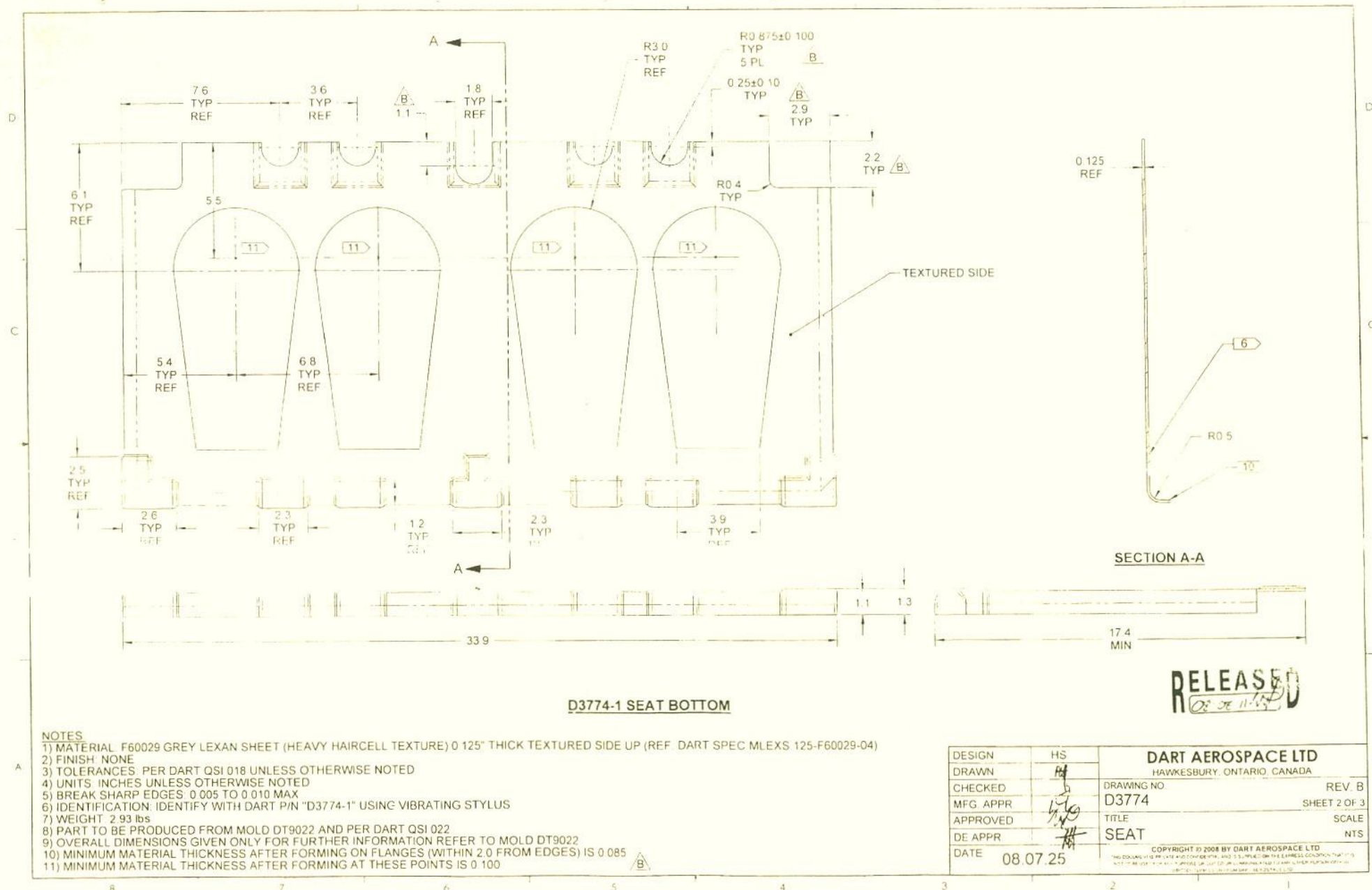


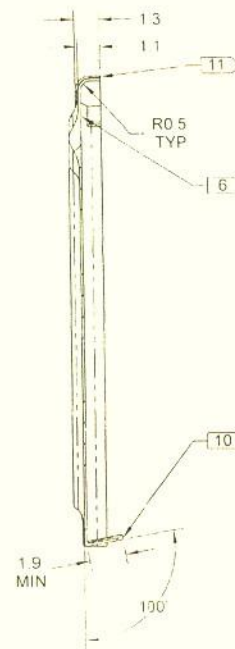
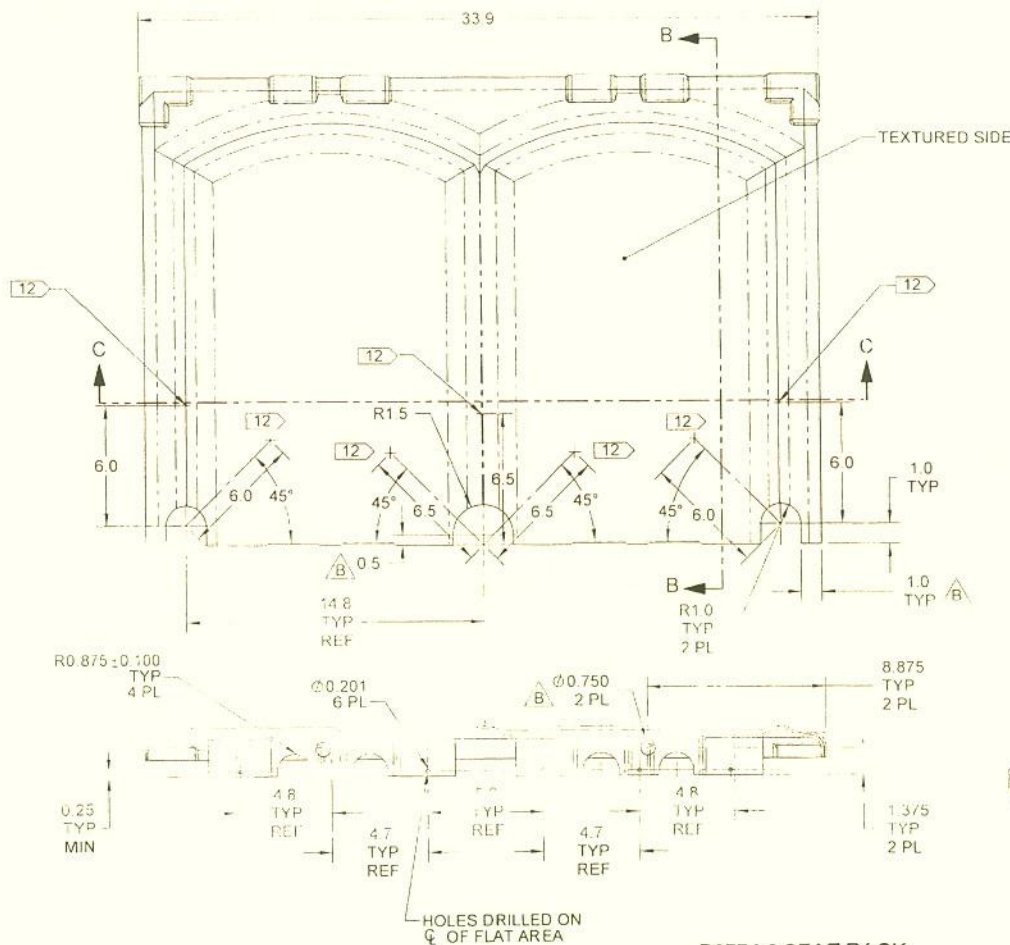
D3774-3 SEAT BACK

129469 MJS
1502 11

RELEASED
08-11-11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3); REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO	REV. B
CHECKED	PH	D3774	SHEET 1 OF 3
MFG APPR	PH	TITLE	SCALE
APPROVED	PH	SEAT	NTS
DE APPR	PH	DATE 08.07.25	
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SECTION B-B



SECTION C-C

D3774-3 SEAT BACK

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS 125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT: 4.82 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-05-11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PS		
CHECKED		DRAWING NO	REV. B
MFG. APPR		D3774	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		SEAT	NTS
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